

Date: Wednesday, 22/04/2009 11:41:17 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 212 X-TUBE ,LOW STANDARD AFT
<b>Job Number</b>	: 47372		
<b>Estimate Number</b>	: 13019		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D212664207
<b>This Issue</b>	: 22/04/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D212-664-247
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 47371	<b>Drawing Revision</b>	: A
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>JD 09.04.22</u>	<b>Due Date</b>	: 29/04/2009
<b>Comment</b>	Est Rev:A New Issue 07.09.12 EC verified by: JLM Est Rev:B ECN 1100p 08-01-11 DD verified by: EC Est Rev:C ECN 1121 08-02-25 DD verified by:ec Est Rev: D QC5 replaced by QC15 at step 5 KJ Verified by: ec		

Qty: 1 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-207 CHG001

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3.0	D212664207TRN	Crosstube Turning Detail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B44592

9-4-27

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-247 using CNC bender program and Folio FT

MB

09-04-28

①

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

S 09/04/28 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212664-207 PAR #: N/A Fault Category: Prod/x-tube NCR: (Yes) No DQA: A Date: 09/05/11  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: A Date: 09/05/11

NCR: <u>47372</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.05.07	7	SEVERE, GRINDING ON CUFF. WALL THICKNESS VARIES BY 0.030. 0.020" DEEP CHAMFER CUTS IN CUFF	<u>MS</u> 09/05/08 PST 042	SCRAP TUBE 08.05.07 Donate to Engineering Lab.	<u>MS</u> 09/05/08	<u>MS</u> 09/05/08 PST 042	<u>MS</u> 09/05/08	<u>MS</u> 09/05/08

NOTE: Date & initial all entries

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Job Number: 47372

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D36601

CUFF



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CUFF

Batch: 44455

RT 09-04-29

7.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Rivet holes as per Dwg D212-664-247 using DT8972.

2-Drill pilot holes in tube as per Dwg D212-664-247 using DT8550 and DT8551

3-Ream hole to finish size in tube as per Dwg D212-664-247

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-247

4-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-247

PTO

RT 09-04-29

AWM 9-4-29

RT 09-04-29

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

QC5

INSPECT WORK TO CURRENT STEP

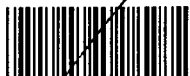


Comment: INSPECT WORK TO CURRENT STEP

11.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES




Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9-4-28	2.1	Cut cuffs to approved height		9-4-28			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47372

Part Number: D212664207

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

13.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

14.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D212-664-247. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291 BATCH: \_\_\_\_\_

*Scrap*

15.0	CR3212406	CHERRY RIVET
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Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

CHERRY RIVET

Batch: \_\_\_\_\_

16.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: \_\_\_\_\_

Fininsh Time: \_\_\_\_\_

PAINT:

Start Time: \_\_\_\_\_

Finish Time: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

18.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support

batch: \_\_\_\_\_

19.0

D3595063530

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rubber Cushion

Batch: \_\_\_\_\_

20.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

Batch: \_\_\_\_\_

21.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Assemble as per Dwg D212-664-247

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3- Instal support with magnobond 6398 per dwg D212-664-247,  
cure for 12hrs before packaging.

Time & date of application: \_\_\_\_\_

Batch: \_\_\_\_\_

EXP. DATE \_\_\_\_\_

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47372

Part Number: D212664207

Job Number:



Seq. #:	Machine Or Operation:	Description :
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22.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

23.0	AN640A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch \_\_\_\_\_

24.0	AN641A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch \_\_\_\_\_

25.0	MS21042L6	Nut
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch \_\_\_\_\_

26.0	AN960JD616	Washer
------	------------	--------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

batch \_\_\_\_\_

27.0	D34281	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

batch \_\_\_\_\_

28.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47372

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-207

*Scrap*

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 09-05-08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

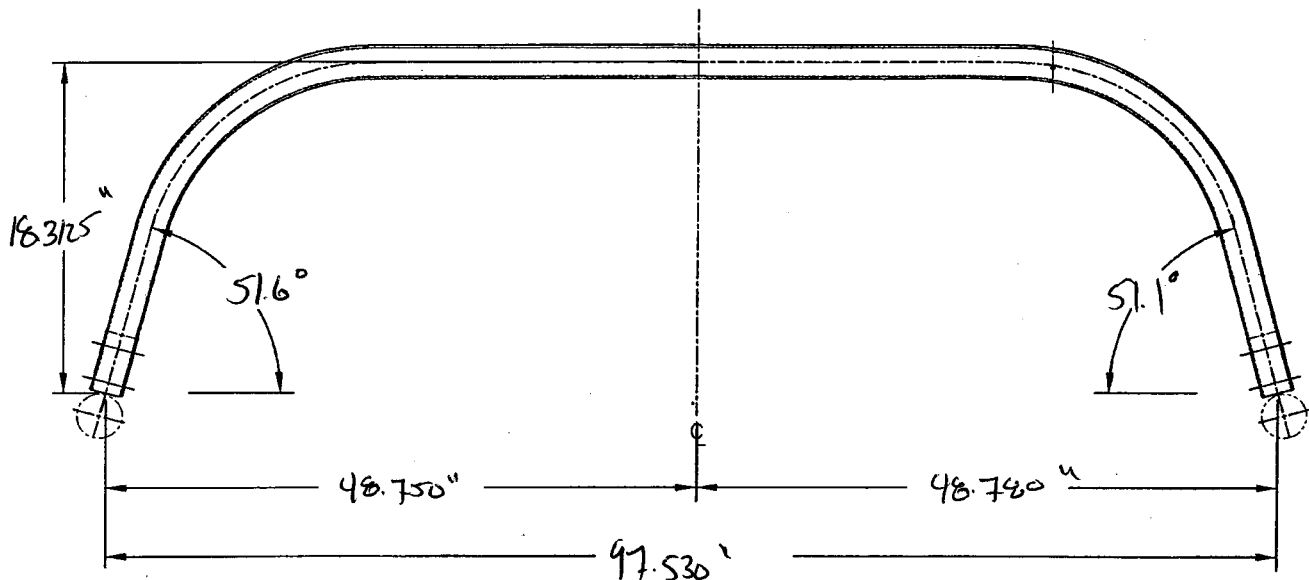
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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	47378
Description: Crosstube Low Aft (205/212)		Part Number:	D212-664-207
Inspection Dwg: D212-664-247 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	18.16	18.42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



Comments

QC15 Inspection	S
Date	09/04/28

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**PARTS LIST:**

Qty	Part Number	Description
X	D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
1	D6008-132	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
2	D3660-1	CUFF
4	MS21920-28	CLAMP (OR MS21920-30)
44	CR3212-4-06	RIVET (OR M7885/3-4-06)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6008-132  
FINISHED LENGTH = 128.27 ± 0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER ON INNER SURFACE OF TUBE WITH A VIBRATING STYLUS.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INS" ALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

RELEASED  
07.07.07

NO WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED  
SUBJECT TO APPROVAL  
RETURN TO  
ENGINEERING  
SHOP COPY

A		07.07.07	NEW ISSUE
DESIGN		DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D212-664-247	SHEET 1 OF 3
07.07.07		CROSSTUBE (205/212 LOW AFT)	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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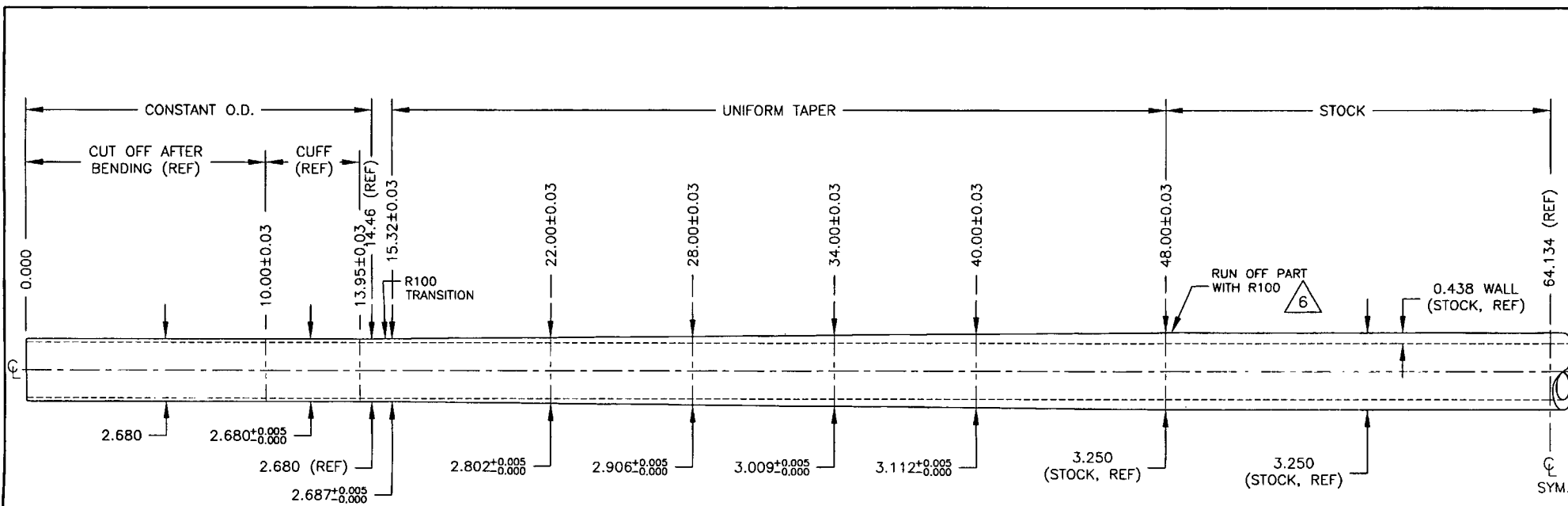
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**NOTE:** Date & initial all entries



# D212-664-247 MACHINING DETAIL

RELEASED  
07.07.24

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 212

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DATE 07.07.07		TITLE CROSSTUBE (205/212 LOW AFT)		SCALE 1:4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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